

STAVIS SEAFOODS, INC.

AMMONIA REFRIGERATION MANAGEMENT PROGRAM STANDARD OPERATING PROCEDURES — LOW STAGE RECIPROCATING COMPRESSOR OPERATION

Standard Operating Procedure (SOP)

Task Flow

Manual start-up procedures

Monitor normal operations

Manual shut-down procedures

Emergency shut-down procedures

Task	Step	Comment
Manual start-up procedures (during normal operations following maintenance operations)	1. Visually check the compressor for lockout/tag-out devices.	IF ANY LOCKOUT/TAGOUT DEVICE IS FOUND THAT WAS NOT INSTALLED BY YOU, IT IS ABSOLUTELY IMPERITIVE THE PERSON WHO INSTALLED SUCH DEVICE BE CONSULTED WITH BEFORE PROCEEDING. During normal operations, the compressor will start, stop, automatically load, and unload based on suction pressure.
	2. Visually check the compressor crankcase oil level sight glass.	Oil should appear to be clean and the sightglass should indicate 1/2 full
	3. Check the crankcase oil temperature thermometer for proper starting temperature	Minimum starting temperature is 100°F If not at minimum temperature, check that the oil heater is on and wait until the oil temperature is at least at the minimum point before attempting to start the compressor.
	4. Check to ensure a sufficient quantity of condenser(s) is enabled to operate.	
	5. Manually open the compressor discharge service valve RCB1-V2 / RCB2-V-2 slowly to (full open)	
	6. Manually open the compressor suction service valve RCB1-V-1 / RCB2-V-1 slowly to (full open)	
	7. Ensure that any manual valves on the oil cooler water supply and return line are open.	Remove any tags associated with valves, valve settings or disconnects on the compressor.
	8. Turn on or reset any disconnects that were turn in the off position.	